

Work Order ID 86567

July-05-12 10:41:37 AM

86567

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Item ID: D3272-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step
 Start Date: 7/05/12 Start Qty: 10.00 ***10* 5** Cust Item ID:
 Required Date: 7/20/12 Req'd Qty: 10.00 ***10* 5** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3272	Rev B

100 Large Fab 0.00
100
 Large Fab Memo 0.00
 Large Fab ***SQUARE ONE END BEFORE CUTTING OTHER END***
 1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A
 2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.
 3-Deburr

110 QC6- Inspect dimensions to drawing 0.00
110
 QC Memo 0.00
 Quality Control

Handwritten notes and signatures:
 5 0 Ae 12.07.17
 DAS 16 89 17/9/17 5 0 Ae 12.07.17

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Item ID: D3272-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Step

Stop *NS2*

Start Date: 7/05/12 **Start Qty:** 10.00 ***10***

Cust Item ID:

Required Date: 7/20/12 **Req'd Qty:** 10.00 ***10***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

Identify as per dwg & Stock Location: WMA

0.00

120

Packaging

Memo

0.00

Packaging

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/7/2017
MLJ 12/07/17

Picklist Print

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Work Order ID: 86567

Parent Item: D3272-1

Parent Item Name: Step

Start Date: 7/05/12

Required Date: 7/20/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	133.0100	1	10			
Step Extrusion													

Ac 12.07.11

Location	Loc Qty	Loc Code
HALL	16.37	
46910	2	
64409	6	
66970	7.7	
68293	0.25	
72131	0.42	
WA	107.28	
81507	2.88	
<u>83894</u>	104.4	
WA013	9.36	
75781	2	
77612	7.36	

5



DESIGN <i>QD</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>JB</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

B

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

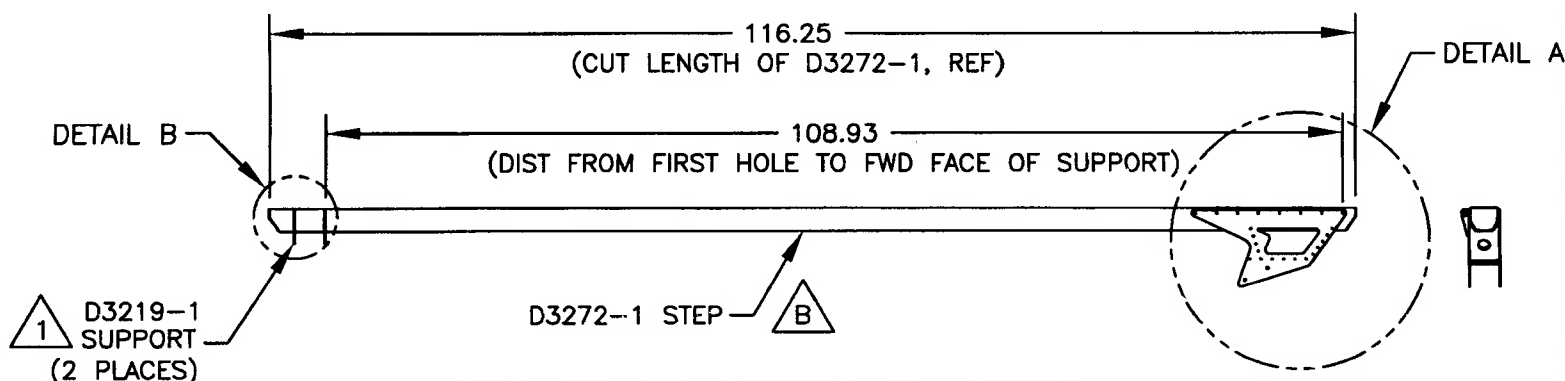
110 86567

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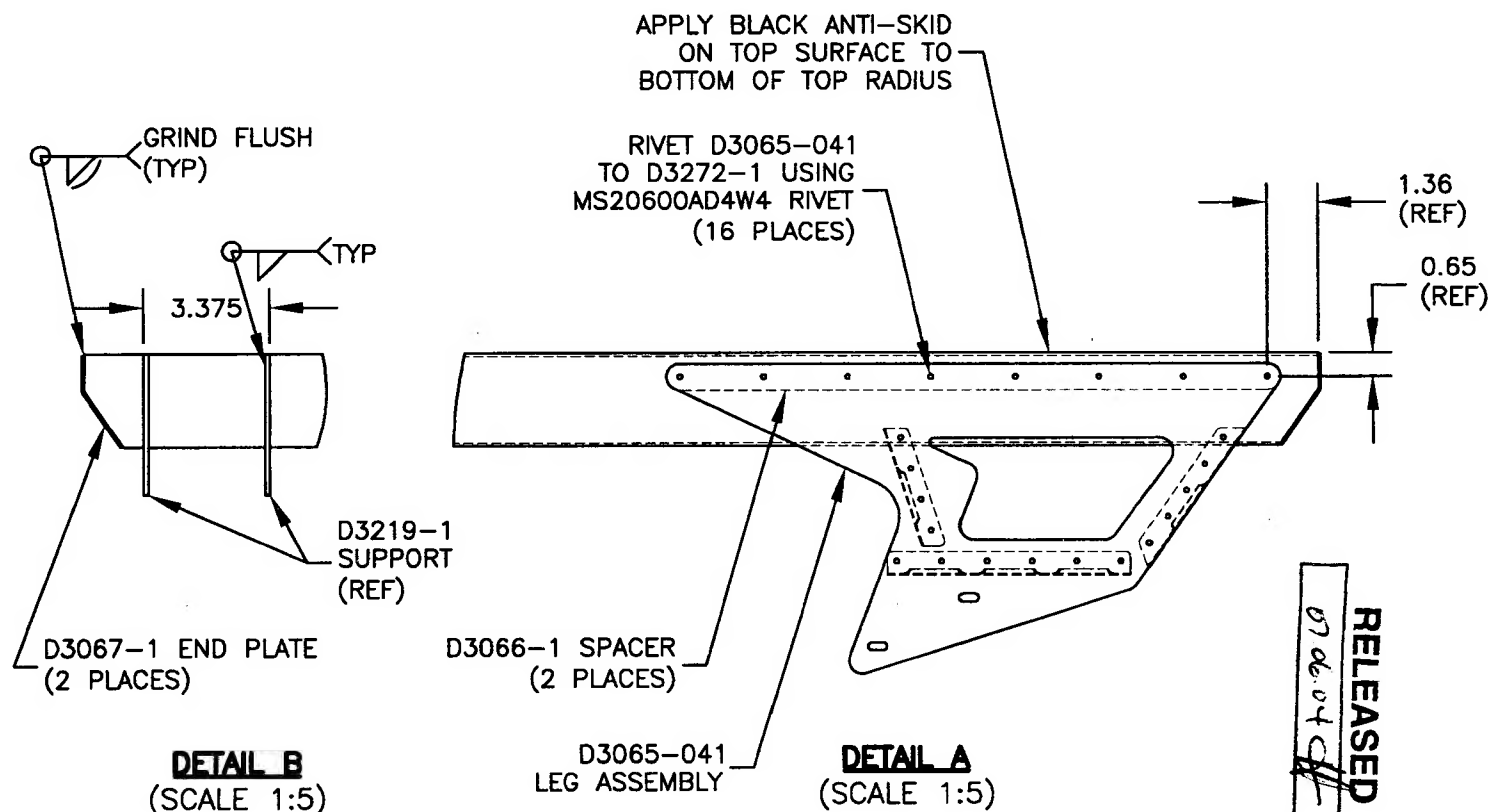
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DART

DESIGN	q	DRAWN BY	JB	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. B
CHECKED	CE	APPROVED	JB	DRAWING NO. D3272	SHEET 2 OF 3
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	SCALE	1:20



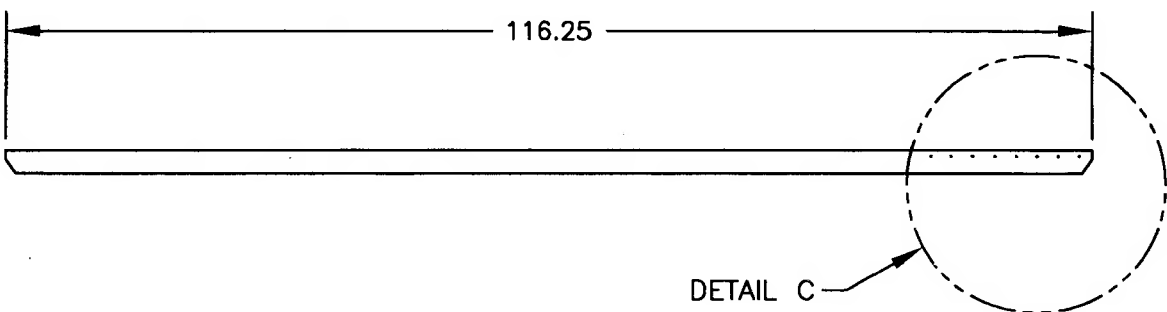
D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



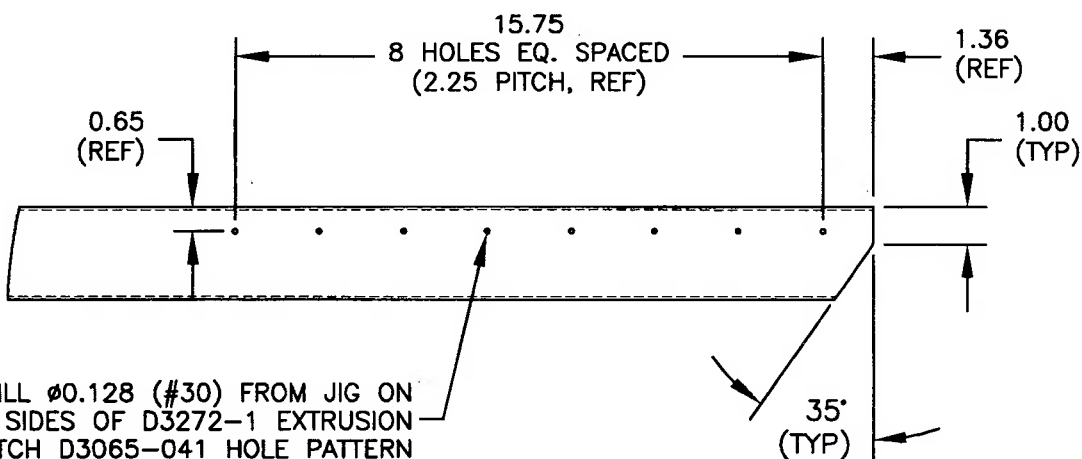
RELEASED
07.06.04

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20	



B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

RELEASED

07.06.04